Work Ord Wednesday, Jan		95675 2013 1:04:59 PM	5 °	*950	675*	···································		7: <u>2. *</u> w	(Jan.	Page 1	
Item ID: Revision ID: Item Name:	D2344 Litter De	eck Plate, 350	T	Accept	*N900	040	100)* s	etup Sta	I /I	S1* S2*	1.21
Start Date: Required Date Reference:	1/16/20 : 1/31/20		*6* *6*		Cust Item Customer:	D:					(1)	
Approvals:	Proces QC:	s Plan: MF	Date: \3-\-'	Tooling: SPC (Y/N):		ate:		Ą	Run Sta Sto	171	R1* R2*	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	-	Revision Nbr						2 -3		·······································	Stamp	
D2344		Rev F										
*100		FLOW WATER JET	······································	0.00						·····	·	_
Waterjet FLOW CNC Water		Memo 1-Cut as pe prog rev: dwg rev:	er dwg	0.00					0		<u>Jm</u>	13-1-24
		2-deburr as	s required									
110		QC2- Inspect parts off r	machine FAI/FAIB	0.00				_				•
110 QC Quality Control		Memo		0.00				7_	0	<u></u>	Jm 13-1	!-24

											DQA:	Date:	
NCR: Y	es	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPI	DATE	·		
											QA Closed:	Date:	
Work Orde						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
work Orde	-	•			-	Rework	7		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-					Use-as-is]	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo					Work Order Update			Large Fab	Composite		Supplier	
B			ſ		Docer	iption of work order update	Т	Initial	- Act	tion	Sign &		
Root Cause		Date	Step	Qty		or Non-conformance	1	hief Eng	1 `	ription	Date	Verification	QC Inspector
 	-	Date	Step	Qty		or tron comornance	+~	mer eng					
Doc/Data	\dashv												
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Operator	_												
Material	_												
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Process											[-	
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Unapproved					İ				<u> </u>			<u> </u>	
						1	FAU	LT CATE	GORY				
Landi	ng G	ear	-	-		General					_		•
	$\overline{}$	Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	are.		Over/Under	tolerance	Temperature/Cure

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Broken/Damaged

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Burrs

Weld

Other

Wrong Stock Pulled

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cracks

Cuffs

Heat Treat

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Work Orde Wednesday, Jan					*956	375*								Page 2
Item ID: Revision ID: Item Name:	D2344 Litter Deck P	Plate, 350	- F 10 1.2	277 2.22	Accept	*N90)((140	100)*	Setup	Start Stop	*N *N	S1* S2*
Start Date: Required Date: Reference:	1/16/2013 1/31/2013	Start Qty: 6.00 Req'd Qty: 6.00		*6* *6*		Cust Ite		:						()/
Approvals:	Process Pl	an:	Date:		Tooling:		Date	e:			Run	Start	*N	R1*
	QC:	· · · · · · · · · · · · · · · · · · ·			SPC (Y/N):		Date	e:				Stop	*N	R2*
Sequence ID/ Work Center II)	Operation Description QC8- Inspect parts - seco	ond check	·——-	Set Up/ Run Hours	Tool I	ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
120 QC Quality Control		Memo			0.00					0	_ 13 <u>-</u> 1	01.9.	2	09
											7			
* 1 30		Small Fab			0.00					1				8
Small Fab		Memo			0.00					TX				7-13

QC5- Inspect part completeness to step on W/O 0.00

*14**0*** Memo Quality Control

140

0.00

												DQA:	Date	e: _	
NCR: Y	es	/ No				WORK ORDER NON-O	100	VFOR	MANCE / UP	DATE		_			
											(QA Closed:	Date	e:	
Work Orde	, ė.				;	DISPOSITION				AGAINST D	EP	PARTMENT/	PROCESS		
Work Orde	:ı. -	:				Rework]		Skid-tube	Crosstube	٦		Water Jet		Engineering
Part N	lo.					Scrap			Machining	Small Fab	\Box	Prod	d. Eng. Coor.		Quality
	•					Use-as-is		Thern	noforming	Finishing	_	Rec/Stor	e/Packaging	_	Other
NCR N	10.					Work Order Update]		Large Fab	Composite	ل		Supplier		
Root				I	Descri	ption of work order update	1	Initial	Ac	tion	Т	Sign &			
Cause	Ì	Date	Step	Qty		or Non-conformance	1	nief Eng	1	ription		Date	Verification	,	QC Inspector
Doc/Data										<u> </u>	7				
Equip/Tooling							١		1						
Operator _			ļ		ĺ				ĺ		ł				
Material 🔏	ì	•													
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Other															
Process															•
Supplier							İ				١				
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		<u> </u>			450		AU	LT CATE	GORY		_				
Landi	ng (Gear			_	General	_	٦		г	_	l	г		- te t
	L	Bending			<u> </u>	Bend	\vdash	Grain		-		Ovalized	<u> </u>		Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route	\vdash	Hardwa		-		Over/Under	· · · · · · · · · · · · · · · · · · ·		Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete			Part Incorred	ct [Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Wrong Stock Pulled

Other

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cuffs

Heat Treat

69

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID	956	75
Wednesday, January 16,		

Work Ord Wednesday, Jan	nuary 16, 201.			*956	75*			Page 3
Item ID: Revision ID: Item Name:	D2344 Litter Deck P	late, 350	rentille of m <u>ulwanel</u>).	Accept	*N900040		Setup Start	18.21
Start Date: Required Date: Reference:	1/16/2013	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item ID: Customer:		·	*NS2*
Approvals:	Process Pla	an:	Date:		Date:		Run Start Stop	"NRT"
Sequence ID/ Work Center II 150 *150* HandFinish Hand Finishing	D	Operation Description Chemical Conversion Co	oat per QSI005 4.1	Set Up/ Run Hours 0.00	Tool ID Tool #	Code Qty	Qty	Reject Insp. Number Stamp
155 *155* QC Quality Control		QC7-Inspect Chemical C	onversion Coat	0.00		7	, ø	13-1-29
*160 *160* Powdercoat Powder Coating		Black Sandtex Ref 4 % 5. Memo STATUTION	7) per QSI005 4.3 E: <u>Zio</u> FINISH TIME:	0.00 0.00 OVEN TEMPERATURE		- F	B & 1	LL13-1-29.

											DQA:	Date:	
NCR: Y	'es /	No				WORK ORDER NON-	COI	NFORN	MANCE / UPDA		QA Closed:	Date:	
NA Comb					·	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orde Part N NCR N						Rework Scrap Use-as-is Work Order Update		Therm	Machining noforming	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				<u> </u>	Descr	ription of work order update	T	Initial	Action		Sign &		
Cause		Date	Step	Qty	1	or Non-conformance	Cr	nief Eng	Descript	ion	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
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Landi	ng Ge	ar				General				****			
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ľ	${f H}$	•	ot Concei	ntric to	o/s	BOM/Route	Г	Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	\vdash	racks		·	·	Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
	-		Crimped		F	Burrs		⊣ `	ions Incomplete/Unc	lear	Part Lost/M	issing	Wrong Stock Pulled
	—	uffs	Jp.cu			Contamination		Mainte	•		Part Moved	_	-
	\vdash	uiis est Tre:	at		-	Countersink		Mislabe			Positioned \	N rong	

Misread

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord Wednesday, Jan			·· - · · · · · · · · · · · · · · · · ·	*956	75*	*** **********************************		Page 4
Item ID: Revision ID: Item Name: Start Date:	D2344 Litter Deck P 1/16/2013	late, 350 Start Qty: 6.00	*6*	Accept	*N90004010	()* Se	etup Start Stop	*NS1* *NS2*
Required Date Reference:	: 1/31/2013	Req'd Qty: 6.00	*6*		Customer:	_	S 44	
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):	Date:	R	un Start Stop	*NR1* *NR2*
Sequence ID/ Work Center I	D	Operation Description QC3- Inspect Part Finish		Set Up/ Run Hours 0.00 15	Tool ID Tool # Plan Code	Accept Qty		Reject Insp. Number Stamp
QC Quality Control		Memo		0.00 13.1	30			
*180 *180* Packaging Packaging		ldentify as per dwg & Stoo Memo	ck Location: <u>ST</u> JDO/	0.00			M	3/c/p20 (2)
190 *190* QC		QC21- Final Inspection - V	Work Order Release	0.00			131	1/31/1
Quality Control		Memo		0.00				

Misorso

WORK ORDER NON-CONFORMANCE / UPDATE NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Crosstube Water Jet Skid-tube Rework Small Fab Prod. Eng. Coor. Machining Scrap Part No. Rec/Store/Packaging Thermo orming Finishing Use-as-is Supplier Large Fab Composite NCR No. Work Order Update

Root				Description of work order update	Initial	Action	Sign &		
Cause	Date	Step	Qty	or Non-conformance	Chief Eng	Description	Date	Verification	QC Inspector
Doc/Data									
quip/Tooling		ļ	1 1					[
Operator									
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Date:

Engineering

Quality

Other

DQA:

Pressure/Forced Ovalized Grain Bend Bending Temperature/Cure BOM/Route Over/Under tolerance Hardware Centre Not Concentric to O/S Broken/Damaged Inspection Incomplete Part Incorrect Weld Cracks Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped Burrs Part Moved Contamination Maintenance Cuffs Positioned Wrong Countersink Mislabeled Heat Treat Other Power Loss/Surge Inspection Strip in Tube Cut Too Short Misread Offset **Drill Holes** Ripples in Bend Drawing Out of Calibration **Torque Waves in Extrusion** Out of Sequence Finish Turning Sequence Folio **Outside Dimensions** Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

Wednesday, January 16, 2013 1:04:58 PM

Work Order ID:

95675

Parent Item:

D2344

Parent Item Name:

Litter Deck Plate, 350

Start Date: 1/16/2013

Required Date: 1/31/2013

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:D00.06.26Removed P/O for powder coatEC IPP Rev:E 07-07-04 Asper Rev F JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 2024-T3 .063 sheet		Purchased	No			100	sf	212.7400	0.745	4 705 2632 4,8		September 1	JM13-1-2
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT022		212.74							
				1199	916	0.2							
				121	197	21.34							
				1230	096	11.4							
				1236	554	12.8							
				1237	701	167			2)2	10P			

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPDATE		QA Closed:	Date:	
		· 100				DISPOSITION			AGAIN		PARTMENT		
Work Ord	er: .					Dawark	7		Skid-tube Crosstu	ا موار		Water Jet	Engineering
Doet 1	Ma					Rework Scrap	1		Machining Small F	-	Pro	d. Eng. Coor.	Quality
Part I	NO.					Use-as-is	1 1	B .	noforming Finish	<u> </u>		re/Packaging	Other
NCR I	No.					Work Order Update]	ł	Large Fab Compos	· -	•	Supplier	
		-	,		,						C: 0		T
Root				_		ption of work order update		Initial	Action		Sign &	Varification	QC Inspector
Cause	, ,	Date	Step	Qty		or Non-conformance	Cr	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling							ļ						
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Material	$ldsymbol{ldsymbol{ldsymbol{eta}}}$,					· ·
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		<u>.</u>					AU	LT CATE	GORY		_		
Land	ing (Gear				General		7		_	1	_	-
		Bending				Bend	\perp	Grain			Ovalized		Pressure/Forced
·		Centre N	ot Conce	ntric to	o/s	BOM/Route	\perp	Hardwa		<u> </u>	Over/Under		Temperature/Cure
		Cracks				Broken/Damaged	L	⊣ `	ior: Incomplete	<u> </u>	Part Incorre	<u> </u>	Weld
1		Crushed/	Crimped			Burrs	L	instruct	tions Incomplete/Unclear	lacksquare	Part Lost/M		Wrong Stock Pulled
		Cuffs				Contamination	L	Mainte	enance		Part Moved		
		Heat Tre	at			Countersink		Mislabe	eled	L	Positioned \	Wrong	
	Г	Inspection	on Strip in	Tube		Cut Too Short		Misrea	d		Power Loss	/Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	95675
Description: Litter Deck Plate Kit (350)	Part Number:	D2344
Inspection Dwg: D2344 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.223	+/-0.010	6.225	-			
5.598	+/-0.010	5.599	-			
4.869	+/-0.010	4,870"	-			
3.889	+/-0.010	3.892	-			
3.096	+/-0.010	3.097	~			
2.891	+/-0.010	2.893"	-			
16.973	+/-0.010	16-933"	-			
0.450	+/-0.010	0.453	-			
4.423	+/-0.010	4.423	-			
4.723	+/-0.010	4.725"	-			
1.202	+/-0.010	1.201"	_			
5.869	+/-0.010	5.870"	-			
4.654	+/-0.010	4.655"	-			
Ø0.656	+0.005/-0.000	Ø 0.657"	-			
1.888	+/-0.010	1,889	-			
2.285	+/-0.010	2.290"	_			
2.683	+/-0.010	2.689	_			
Ø0.171	+0.005/-0.000	PO. 171"	-			
3.491	+/-0.010	3.495"	_			
Ø0.191	+0.005/-0.000	0.191"	~			
3.123	+/-0.010	3.129"	-			
1.975	+/-0.010	1.577"	-			
Ø0.128	+0.005/-0.001	0./29	-			

Measured by:	Jm	Audited by:	09	Prototype Approval:	N/A
Date:	13-1-24	Date:	13-01-25	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
В	07.07.17	Dwg Rev. updated	KJ/JLM	
С	07.09.06	Dimensions updated per Dwg. Rev. F	KJ/JLM	B
				

NCR.	Ves	1	Nο	

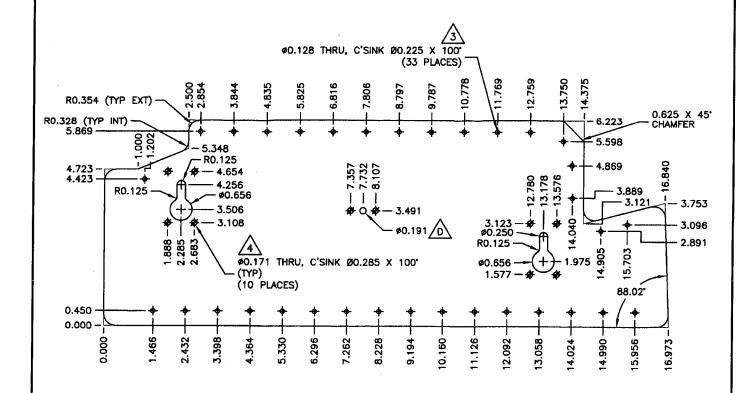
DQA: _____ Date: ____

NCR: Ye	es / No				WORK ORDER NON-C	CONFC	JKIVIAN	JE / UP		QA Closed:	Date	:
Mode Order		DISPOSITION AGAINST DEPARTMENT/PROCESS										
Work Order: Rework						7 	Skid-tube Crosstube		Crosstube	Water Jet		Engineering
Part No) .				Scrap	11	Machir	ning	Small Fab	Prod. Eng. Coor.		Quality
					Use-as-is		Thermoforming Finishing			Rec/Store/Packaging		Other
NCR No	D				Work Order Update	-	Large	Fab	Composite		Supplier	
Root				Descri	iption of work order update	Initi	1		tion	Sign &	_	
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data						1						ŀ
quip/Tooling	_						ļ					
Operator			•									
Material	_				•							
Setup		1										
Other	_											
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Landin				_	General					lo " '	r	Pressure/Forced
	Bending			_	Bend	<u> </u>	ain		<u> </u>	Ovalized		⊣
1	Centre N	ot Conce	ntric to (^{O/S} -	BOM/Route		Hardware			Over/Under	<u> </u>	Temperature/Cure Weld
1	Cracks		Broken/Damaged		Inspection Incomplete		,,,,,,,,,,,, <u> </u>	Part Incorred	—	Wrong Stock Pulled		
	Crushed/Crimped Burrs				—	Instructions Incomplete/Unclear			Part Lost/Mi	ssing	wrong Stock Pulled	
1	Cuffs Contamination				_	aintenance	<u>;</u>		Part Moved	Maran		
1	Heat Trea			<u> </u>	Countersink	 	slabeled		<u> </u>	Positioned V		Toubar
1	Inspection		Tube		Cut Too Short		sread -		L	Power Loss/	Surge	Other
1	Ripples in			_	Drill Holes	\vdash	fset				·	
Ļ	 '	Vaves in		n	Drawing	—	t of Calibra					
L	Turning S	-			Finish	-	it of Sequen			-		
İ	Wave/Twist in Tube Folio					Ou	Outside Dimensions					

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DESIG KE	3N	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHEC	KED	APPROVED	1	/. F
DATE	-	101	D2344 SHEET 1 0	
DAIL			TITLE	ALE
07.0	06.07		LITTER DECK PLATE, 350	1:3
A		95.01.14	NEW ISSUE	
В		95.02.09	MOVED KEY HOLES .	
D		95.03.06	0.191 WAS 0.197	
E		98.06.19	0.063-0.071 THICK WAS 0.071 (TSR A371)	
F		07.06.07	C'SINK Ø0.285 WAS Ø0.308	



D2344 LITTER DECK PLATE, 350

1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063-0.071 THICK PER QQ-A-250/4 (REF. DART SPEC. M2024T3S)

2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
3) COUNTERSINK HOLES MARKED \$\rightarrow\$ TO \$\rightarrow\$0.225 \times 100^\circ\$
4) COUNTERSINK HOLES MARKED \$\rightarrow\$ TO \$\rightarrow\$0.285 \times 100^\circ\$

5) BREAK ALL SHARP EDGES 0.005 TO 0.010

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED 8) IDENTIFY WITH DART P/N "D2344" USING WHITE PAINT MARKER

RELEASED

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	\/	,	A1 -
NCR:	Yes	/	No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

NCK: YE	es / NO				MOUK OUDER HOH-	COIL		MARCE / OF		QA Closed:	Date	e:	
Mork Order					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Work Order:					Rework			Skid-tube	Crosstube		Water Jet	Engineering	
Part No	o				Scrap]		Machining	Small Fab	4	d. Eng. Coor.	Quality	
NCR N	0		* **		Use-as-is Work Order Update	_		oforming Large Fab	Finishing Composite	~ 			
Root				Descr	iption of work order update	li	nitial	Ac	tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chi	ief Eng	Desc	ription	Date	Verification	QC Inspector	
oc/Data													
quip/Tooling						1							
Operator													
Material													
Setup			İ							-			
Other		1											
Process													
Supplier													
Training						ļ							
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		-				FAUL	T CATE	GORY					
Landin	g Gear				General	_			_	7	r		
	Bending			L	Bend		Grain		<u> </u>	Ovalized]	Pressure/Forced	
ſ	Centre N	ot Conce	ntric to	o/s	BOM/Route	Hard		re		Over/Under	tolerance	Temperature/Cure	
	Cracks				Broken/Damaged	Inspe		on Incomplete	ļ	Part Incorrect		Weld	
Ī	Crushed	Crimped			Burrs		Instruct	ions Incomplete/	/Unclear	Part Lost/M	ssing	Wrong Stock Pulled	
	Cuffs				Contamination		Mainte	enance		Part Moved			
Ī	Heat Tre	at			Countersink		Mislabe	eled		Positioned \	Vrong		
	Inspection	n Strip ir	Tube		Cut Too Short		Misread	Ė		Power Loss/	Surge	Other	
	Ripples i	n Bend			Drill Holes		Offset						
	Torque V	Vaves in	Extrusio	n	Drawing		Out of	Calibration					
	_	Sequence			Finish		Out of	Sequence					
	Waye/Twist in Tube				Folio		Outside Dimensions						

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